CG 36 CODE RT-695-D PKG ___ PROCESSES ( )RT-695-D (O) APPROVED BY JJG 3/18/81 EWK 12/7/81

OCT 18 1982 K2K68

(DATE) (LOT NUMBER) COMTYP JOB NAME = 36RT695DMO

TYPED BY: KLW

EST. WT. 2608* LBS. STANDARD HRS. _____ TIME 11 P M.

PREPARATION NOTES: B.O. V-317 Done

NON-BLEEDING

EQUIPMENT		NAME: "BON" RED DARK	USE LBS	N-CODE	ACCT LBS
PREP 1	1	IF NECESSARY, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15# DICALITE FILTER AID	_____	777-A	_____
	2	OBTAIN FOR S 6 2-CHLORO-4-AMINO TOLUENE-5 SULFONIC ACID		740-C	
	3	OBTAIN FOR S 42 3-HYDROXY-2-NAPHTHOIC ACID		82-C	
317 2	4	RUN 23" (732G) WATER INTO V-317			
	5	WEIGH & POUR IN SODIUM HYDROXIDE M 12, 50.16 %	429	7-D	215
	6	TURN ON AGITATOR & STEAM & DUMP IN FROM S 2 2-CHLORO-4-AMINO-TOLUENE-5-SULFONIC ACID		740-C	1104
check weight & Record on back page		LOT 100% %			
		323 643 98.47	653		
		322 320 98.52	325		
		314 141 98.45	143		
	7	~~WEIGH ON POSTAL SCALE 2 AMINO TOLUENE 5 SULFONIC ACID & ADD LOT~~ _____			
	8	DUMP IN ACTIVATED CARBON	50	113-B	50
	9	DUMP IN DICALITE, FILTER AID	10	777-A	10
	10	HEAT TO 214-216 DEG. F WATCH FOAM			
	11	RECORD: BY + (+), IF NECESSARY ADJUST TO + BY SODIUM HYDROXIDE ASSUME 50%	_____	7-D	_____
	12	STIR 30 MIN. AT 212-214 DEG. F, THEN SHUT OFF STEAM WATCH FOAM NOTE RECORD: SPARKLER PRESSURE 0 PSI IF NOT ZERO, NOTIFY SUPERVISOR			
	13	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 15 RECORD: HT 195 DEG.F & RECORDER 195 DEG.F RECORD: START 2:05 TOTAL MIN 15 CLARITY CLEAR			
100 3	14	RUN #1 (99G) WATER INTO V-100			
	15	WHEN S-13 COMPLETE, PUMP V 317 THRU SPARKLER. MAINTAIN V-317 AT 190-195 DEG.F RECORD: START 2:20 TOTAL MIN 15 SAMPLE FROM HOSE. SHOW TO SUPV'R FOR OK			

OCT 22 1982

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EQUIP MENT		PAGE 02 OF 04 CG 36 CODE RT-695-D (0)	USE LBS	N-CODE	ACCT LBS
317 4	16 - 17	WHEN S 13 COMPLETE, CLOSE V-317 OUTLET & STOP PUMP RUN IN 7" (216G) WATER & HEAT TO 190-195 DEG F			
317 CONT'D 4	18	CIRCULATE THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 19 & RECORD: HT_____DEG. F & RECORDER RECORD: START____TOTAL MIN____CLARITY CLEAR			
100 5	19 20 21 22 23 24 25	WHEN S 18 IS COMPLETE, PUMP V-317 THRU SPARKLER INTO V-100 RUN IN 5" (90G) WATER & HEAT TO 190-195 DEG. F CIRCULATE 15 MIN THRU SPARKLER, PUMP V-317 THRU SPARKLER INTO V-100 WHEN MT, BLOW OUT SPARKLER INTO V-100 HEAT TO 165-170 DEG. F (TAKE 1 QT. SAMPLE) (WITH AGITATION ON) TEST FOR CLARITY OF SOLUTION. SHOW 1 QT. SAMPLE TO SHIFT SUPERVISOR FOR APPROVAL (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N-740-C IS AVAILABLE IN OFFICE TO COMPARE WITH) IF S 23 IS OK, CONTINUE WITH S 25. IF S 23 IS NOT ACCEPTABLE, RECLARIFY THRU SPARKLER IF S 23 IS OK, REHEAT V-100 TO 165-170 DEG. F FOR S 26			
100 6	26 27 28 29 30	ADJ TO 16" (1590G) HEAT V-100 TO 165-170 DEG. F RUN IN V-324 HYDROCHLORIC ACID THRU DIRECT LINE AND RINSE IN M 2, 3401 % STIR 15 MIN AT 165-170 DEG. F ADJ TO 50" (4970G) AT 34-38 DEG. F RECORD: TEMP 32 DEG. F AND IF NECESSARY ADJ TO 34-38 DEG. F & RECORD: TEMP_____DEG. F	1429 55 50X330 _____	28-D 57-A 57-A	443 1850 _____
107 7	31 32 33 34 35 36 37 38 39	RUN 45" (4320G) WATER INTO V-107 TURN ON AGITATOR AND STEAM AND DUMP IN MANGANESE SULPHATE DUMP IN BARIUM SULPHATE HEAT TO 150-160 DEG. F AND STIR RECORD: PH 5.9 (5.0-5.5) IF PH ABOVE 5.5, ADJ TO PH 5.5 OR LOWER SULFURIC ACID ASSUME 78% RECORD: PH 5.4 NOTE: IF PH BELOW 5.0, DO NOT ADJ UPWARD HOLD FOR S 58	1400 250 1 	336-B 65-A 27-D 	1400 250 1

MAKING INSTRUCTIONS: BATCH UNIT

EQUIPMENT		PAGE 03 OF 04 CG 36 CODE RT-695-D (O)	USE LBS	N-CODE	ACCT LBS
322 8	40	RUN IN 47* (1610G) WATER INTO V-322			
	41	WEIGH AND POUR IN SODIUM HYDROXIDE M 12 , 50.16 %	937	7-D	470
	42	DUMP IN FROM S 3 3-HYDROXY-2-NAPHTHOIC ACID LOT 8290 8272 7568 Check Weigh & Record on back page	753 147 44	82-C	944
	43	WEIGH 1-HYDROXY-2-NAPHTHOIC ACID ON POSTAL BALANCE AND ADD LOT 95730	10	180-C	10
	44	HEAT TO 70-90 DEG. F			
	45	SIFT IN BLANCOL N IN ONE TO TWO MINUTES	27	567-B	27
	46	DUMP IN TETRASODIUM PYROPHOSPHATE & STIR 5 MIN OR LONGER TO DISSOLVE	8	479-D	8
313/ 9	47	WEIGH SODIUM NITRITE & POUR INTO V-313 FOR S 50 M 9 , 33.36 %	1074	725-A	365
322 10	48	ADJ V-322 TO 65* (2240G) AT 77-80 DEG. F & RECORD: TEMP 80 DEG. F			
	49	SLURRY TRISULPHOIC SOAP D WITH 30 GALS WATER IN DRUM. POUR IN AND STIR 5 MIN.	160	39-A	160
100 11	50	RUN IN N-725-A FROM S 47 AFAP INTO V-100			
	51	STIR 30 MIN AT 36-38 DEG. F MAINTAINING +CR, +KI		57-A	
	52	RECORD: TIME START 5:25 A CR + KI + TEMP 34 DEG. F			
		NOTE:			
		(1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS HYDROCHLORIC ACID ASSUME 32% RECORD: CR (+), KI (+)		28-A	
		(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS SODIUM NITRITE ASSUME 33% RECORD: CR (+), KI (+) TEMP DEG. F		725-A	
→	53	COUPLE V-322 THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (USE 9/16" ORIFICE) RECORD: START 6 A.M. TOTAL MIN 95			
	54	WHEN S 53 COMPLETE STIR 15 MIN			
	55	RECORD: DIAZO — (-), BASE + (+) PH 12.0 (7.0-8.0) TEMP 55 DEG. F (60-65 F)			
		NOTE:			
		(1) IF PH IS 5.0-7.0, WEIGH AND DUMP IN 30# "AS IS" N-7-D DILUTED TO 30 GAL AFAP SODIUM HYDROXIDE ASSUME 50%		7-D	
		(2) (FOR PH ADJUSTMENTS USE ONLY DILUTED N-28-D AND N-7-D)			
	56	ADJ TO PH 8.5-9.0 (SEE ATTACHED PH ADJ AID) HYDROCHLORIC ACID ASSUME 32%	35	28-D	11
		(1) IF PH IS 6.5-7.0, WEIGH 35# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN & RINSE IN PT. STIR 5 MIN & RECORD: PH 9.0 (8.5-9.0)			

DUP050103682

EQUIP MENT		PAGE 04 OF 04 CG 36 CODE RT-695-D (O)	USE LBS	N-CODE	ACCT LBS
100 11 CONT		2) IF PH IS 7.0-7.5, WEIGH 30# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. & RINSE IN PT. STIR 5 MIN & RECORD: PH_____(8.5-9.0)			
		3) IF PH IS 7.5-8.0, WEIGH 25# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. RINSE IN PT. STIR 5 MIN & RECORD: PH_____(8.5-9.0)			
		4) IF PH IS 8.0-8.5, WEIGH 5# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. & RINSE IN PT. STIR 5 MIN & RECORD: PH_____(8.5-9.0)			
		5) IF PH IS 8.5-8.9, WEIGH 1# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. & RINSE IN PT. STIR 5 MIN & RECORD: PH_____(8.5-9.0)			
		6) IF PH IS ABOVE 9.5, DO NOT ADJUST			
	57	RECORD: PH_____SODIUM HYDROXIDE ASSUME 50%	_____	7-D	_____
		NOTE: ADD N-28-D IN 5# "AS IS" INCREMENTS TO APPROACH PH 8.5-9.0 THEN USE LESS N-28-D HYDROXHLORIC ACID (CONCENTRATED N-28-D & N-7-D AND TOO LOW COUPLING TEMPERATURE CAUSES MASSTONE TO GO TOO LIGHT)			
	58	SHUT OFF AGITATOR			
107 12	59	DURING S 53 HEAT V-107 TO 210-212 DEG. F & SHUT OFF STEAM			
		NOTE: IF NECESSARY REHEAT V-107 TO 210-212 DEG. F PRIOR TO START OF STRIKE			
	60	PUMP V-100 INTO V-107 IN 70-75 MIN. LET V-107 TEMP DROP TO 200-205 DEG. F DURING STRIKE THEN MAINTAIN AT 200-205 DEG. F FOR BALANCE OF STRIKE WITH AGITATOR SHUT OFF IN V-100			
		RECORD: START 825 TOTAL MIN 95			
	61	WHEN STRIKE COMPLETE, HEAT TO 210-212 DEG.F			
	62	STIR 15 MIN AT 210-212 DEG. F			
	63	FLOOD TO 180-190* (18240G)			
		RECORD: PH 6.8 (6.5-7.2) AND STOP AGITATOR			
		BOIL OUT VAT 317	50	N-7-D	25

START	FINISH	OPERATOR
9:30 PM	11:00 PM	320
12:15 AM	7:A.M.	54-39
7Am	11Am	282

DUP050103683

CODE: RT-695D LOT K2K68

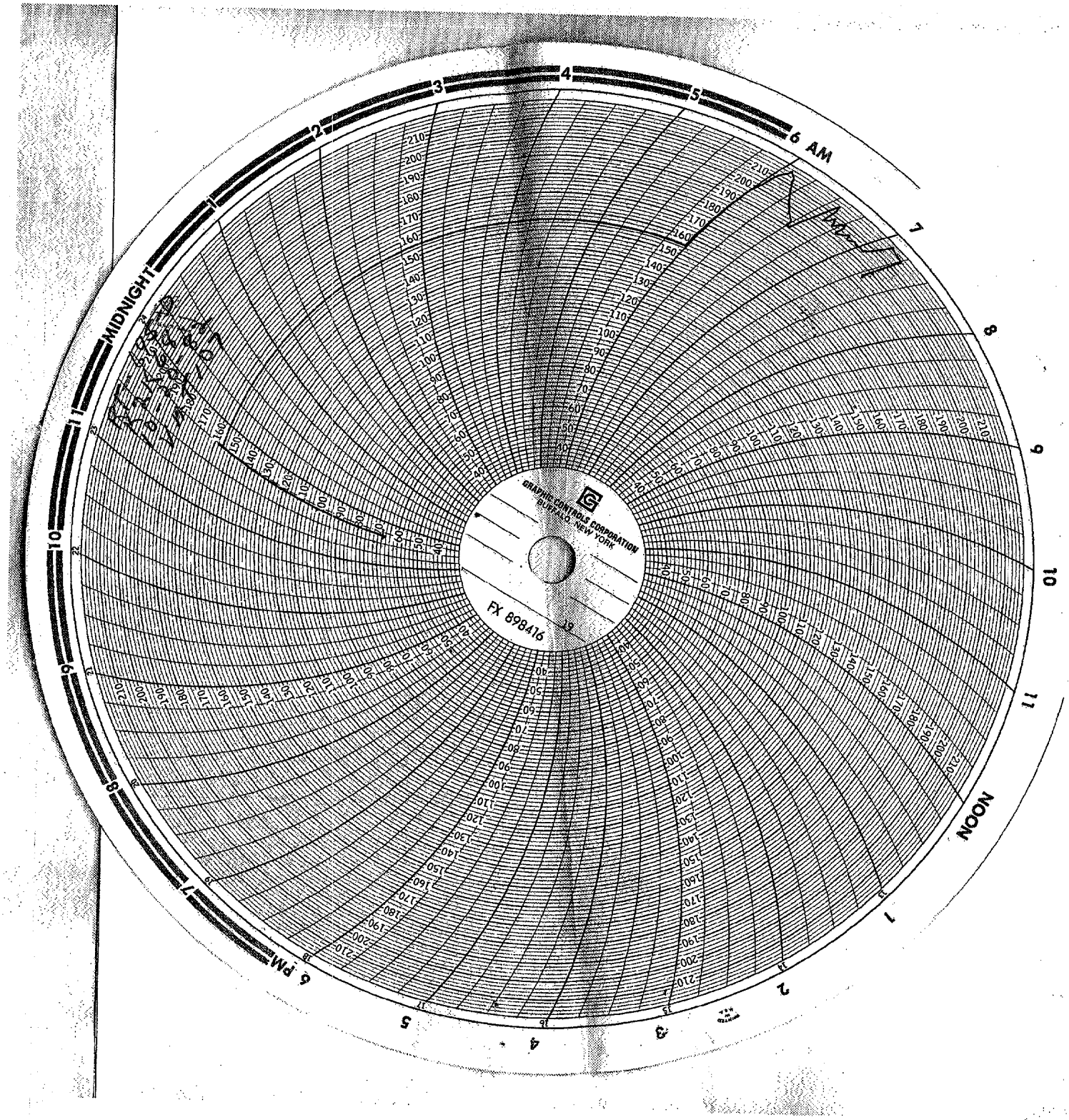
N- 74U -C CHECK-WEIGH & CALCULATE

DRUM STENCILED					NEWARK CHECK-WEIGH				
LOT	GROSS	TARE	Net	%	GROSS	TARE	NET	X % AS DECIMAL	#100%
323	344		325	98.47	344	16	328	98.47	323
323	341		325	98.47	341	16	325	98.47	320
322	342		325	98.52	342	16	325	98.52	320
314	STUMP			98.45	STUMP		143	98.45	141

N- 82 -C

8290	266	16	250		266	15	251		
"	266	16	250		266½	15	251		
"	266	16	250		266	15	251		
8292	266	16	250		162	15	147		
7568	266	16	250		STUMP		44		
							944		

DUP050103684



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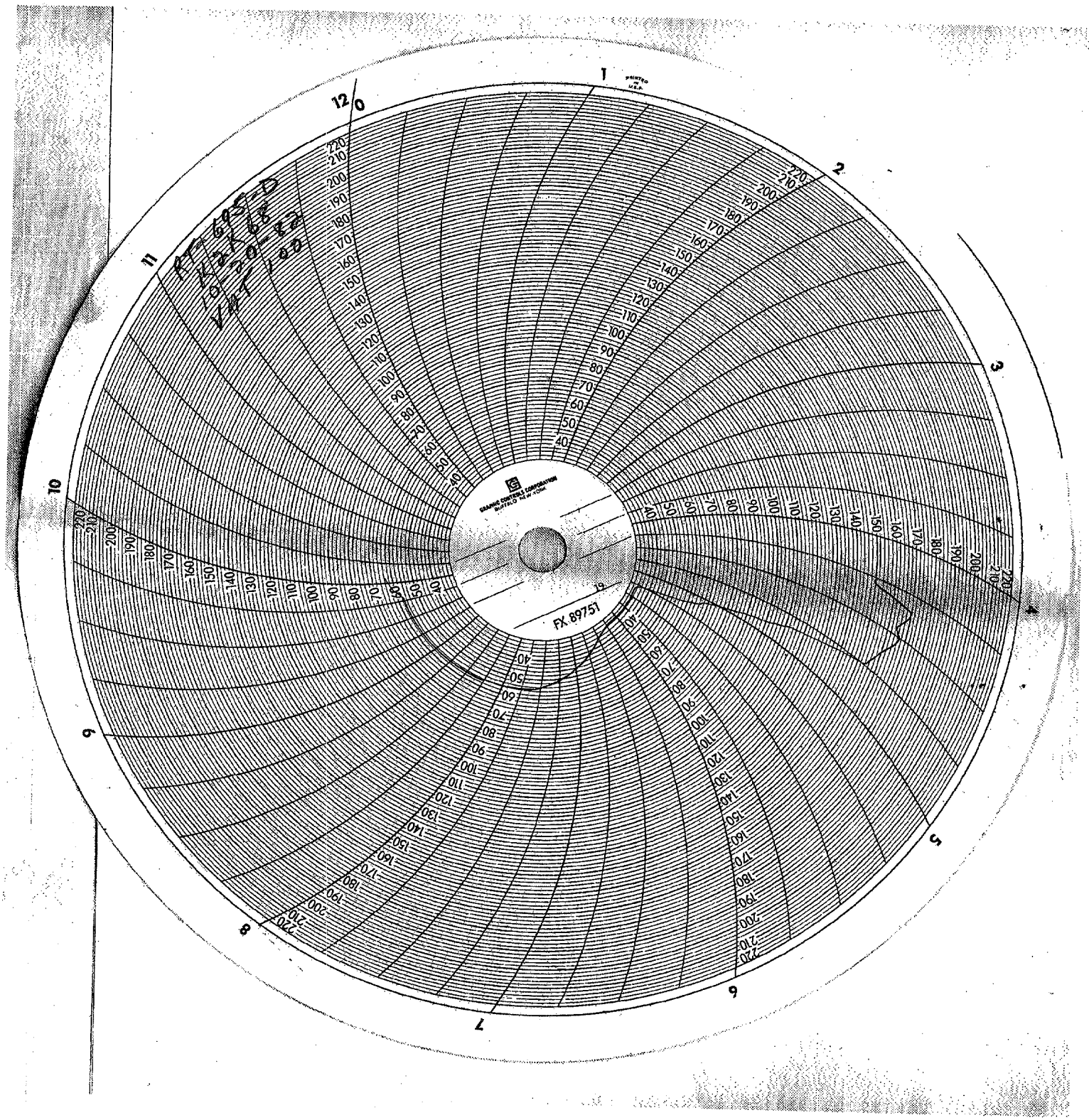

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